

Date: Monday, 3/17/2008 11:57:05 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : LUG BRACKET
Job Number : 38033	
Estimate Number : 10010	
P.O. Number :	Part Number : D27353
This Issue : 3/17/2008 S.O. No. :	Drawing Number : D2735 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : / /	Drawing Revision : C
Previous Run : 37439	Material :
Written By :	Due Date : 3/31/2008 Qty: 40 Um: Each
Checked & Approved By : <u>JB 080317</u>	
Comment : Est Rev: C Removed from 9 Digit 05-10-25 JLM	
Est: C 06.07.21 waterjet EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M1010S125	1010-1025 sheet .125
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Comment: Qty.: 0.1733 sf(s)/Unit Total : 6.9300 sf(s)

1010-1025 sheet .125

batch: 107513 JB 8-3-25

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D2735

Dwg Rev: C JB 8-3-25

Prog Rev: C

2-Deburr if necessary JB 8-3-25

(45)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

JB 8-3-25

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

JB 08/03/25 (45)

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

1-Form D2735-1 as per Dwg D2735. Use CNC Brake Jig DT8204

2-Deburr if required.

JB 08/04/02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 3/17/2008 11:57:05 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG BRACKET

Job Number: 38033

Part Number: D27353

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 08/04/02 K48

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST244 (Temporary)

08/04/03

K45

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/04/04

Job Completion



u 08.04.03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

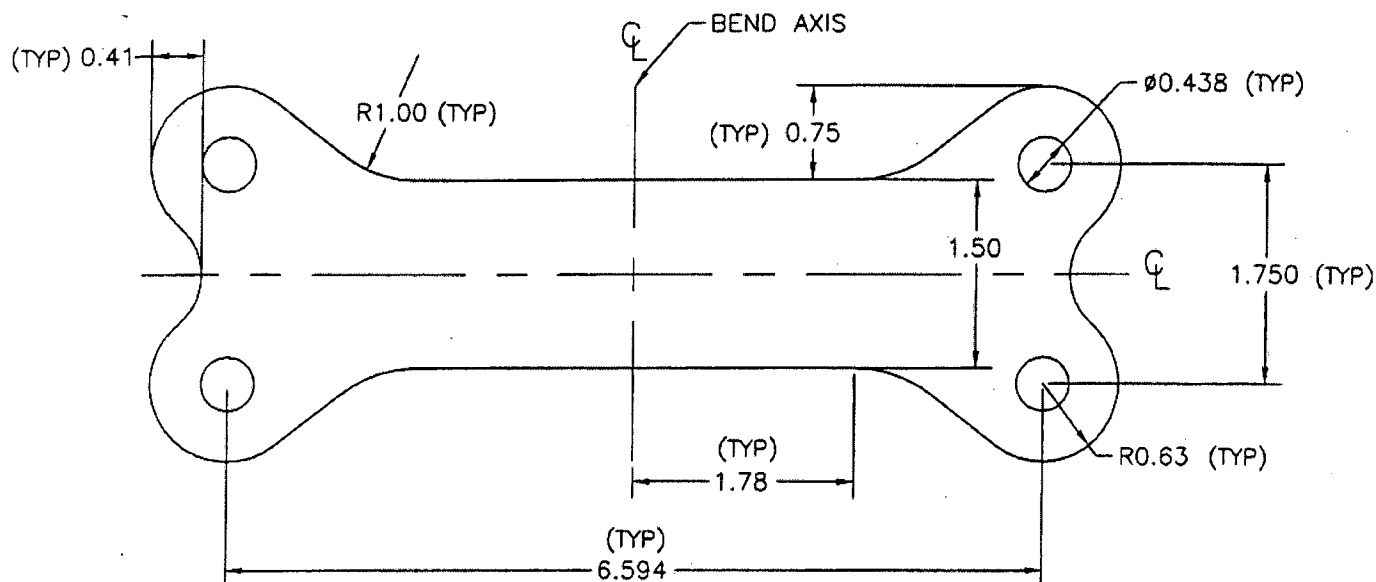
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

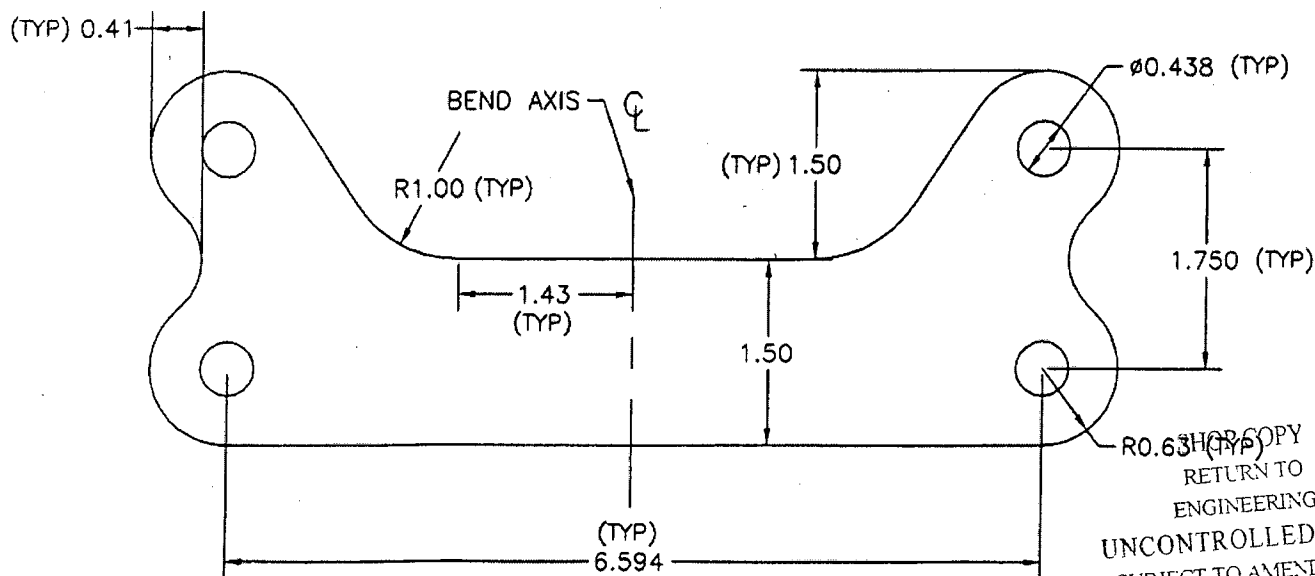


DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CP</i>	APPROVED <i>KE</i>	DRAWING NO. D2735	REV. C SHEET 1 OF 2
DATE 98.12.14		TITLE LUG BRACKET	SCALE 2:3
A	97.12.14	NEW ISSUE	
B	98.10.23	UPDATE MATERIAL (TSR A1114)	
C	98.12.14	REMOVE TOOLING HOLES (TSR A1040)	

RELEASED
98.12.14 DS

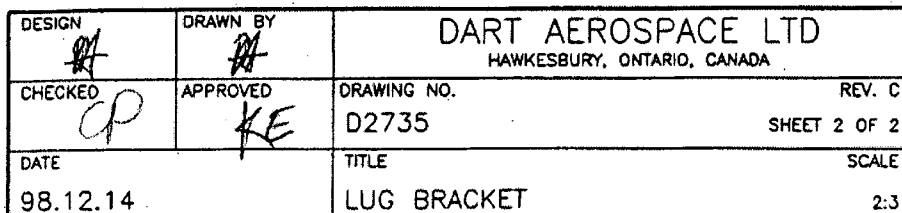


D2735-1 FLAT PATTERN
SYMMETRIC ABOUT BOTH CENTRE-LINES (CL)

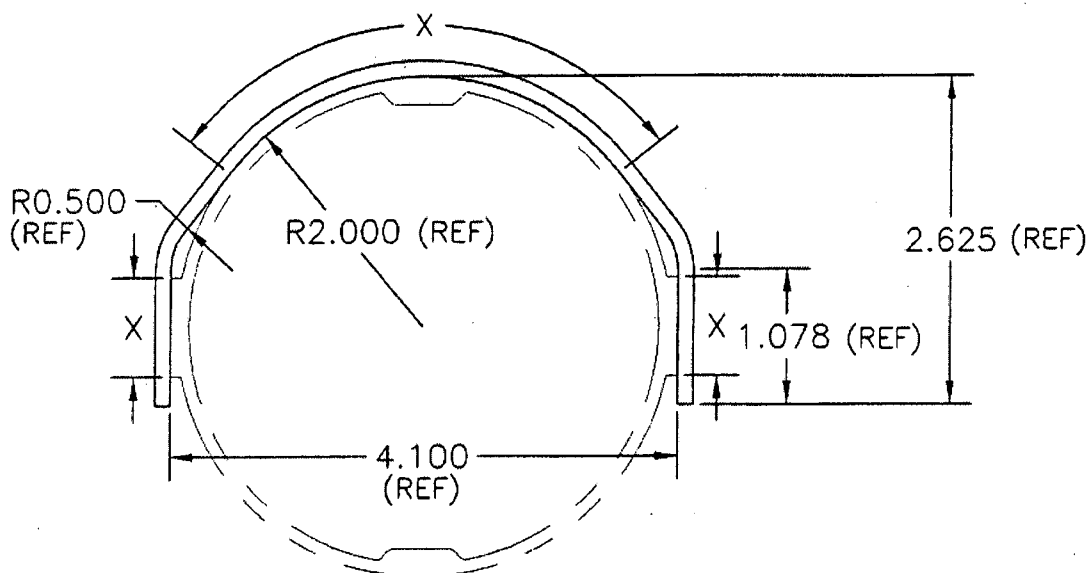


D2735-3 FLAT PATTERN
SYMMETRIC ABOUT CENTRE-LINE (CL)

UNCONTROLLED COPY
RETURN TO
ENGINEERING
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 38033



RELEASED
98.12.14 DS



D2735-1 AND D2735-3 BEND DETAIL

D2735-1 AND D2735-3 SHOULD BE BENT TO WITHIN 0.010 OF THE OUTSIDE PROFILE OF THE D2500-1 EXTRUSION IN THE AREAS INDICATED 'X' ABOVE.

GENERAL NOTES

MATERIAL: ASTM A36/A366/A569/A570 OR AISI 1010-1025 STEEL
0.125 THICK (11 GAUGE)
MIN. ULTIMATE TENSILE STRENGTH = 42 ksi
MIN. YIELD TENSILE STRENGTH = 28 ksi

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES UNC

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 38033